

Work Order ID 109208

Thursday, November 14, 2013 4:06:27 PM

109208

Ship monday

Page 1

Item ID: D2282-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: T Assembly

Start Date: 11/14/2013 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: *ME*

Date: 13-11-19 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2282	Rev E

100		0.00							
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100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-041 'T' Handle Assembly
Grind chamfers and ensure full penetration as per dwg D2282
*****brush weld right after welding, to take color off *****
A/RER316L SS Filling Rod *in 126648*

3 *2* *13-11-15*

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
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110

QC

Memo

0.00

Quality Control

3x *DAS 43* *13-11-15*

120		0.00							
-----	--	------	--	--	--	--	--	--	--

120

Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

3x *13-11-15*

Start @ 12:00pm

Finish @ 3:00pm

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Page 2

Item ID: D2282-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: T Assembly

Stop *NS2*

Start Date: 11/14/2013 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 11/14/2013 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAS
27
9-89

13/11/18

3

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

SHIP

13/11/18 (3)

DAS
32
9-89

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

ML5 13-11-18

13-11-18

Picklist Print

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Page 1

Work Order ID: 109208
 Parent Item: D2282-041
 Parent Item Name: T Assembly

Start Date: 11/14/2013 Required Date: 11/14/2013
 Start Qty: 3.00 Required Qty: 3.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3 Tube		Manufactured	No			100	Each	31.0000	1	3			
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EL 13-11-15

Location

Loc Qty

Loc Code

WA
 107670
 WA002
 74969

20
 20
 11
 11

3

D2282-5 Tube		Manufactured	No			100	Each	49.0000	1	3			
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EL 13-11-15

Location

Loc Qty

Loc Code

WA001
 74962
 WA002
 92093

11
 11
 38
 38

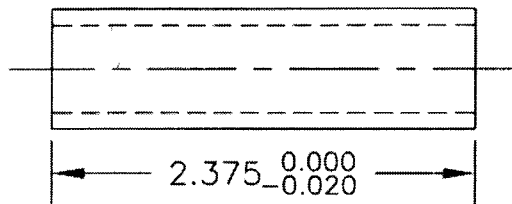
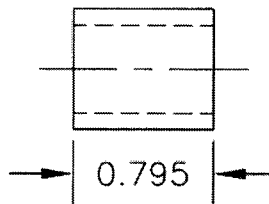
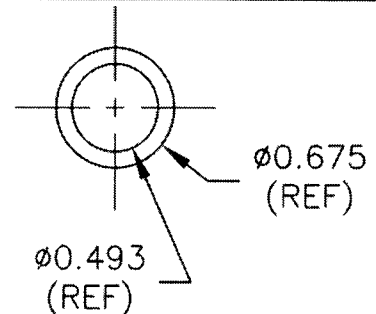
3

DART

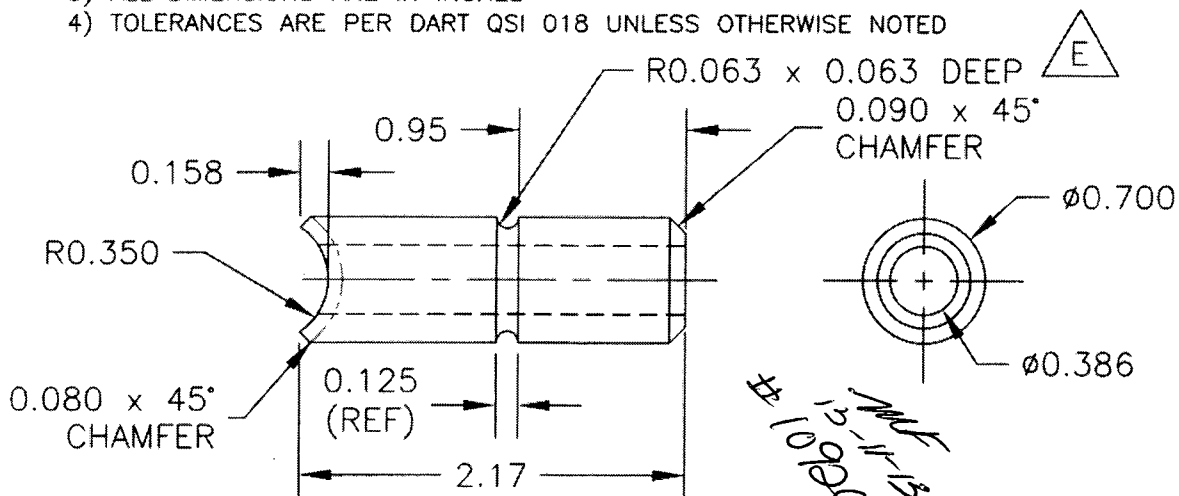
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

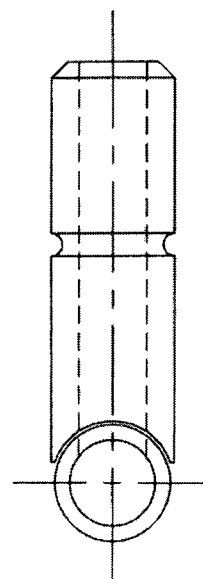
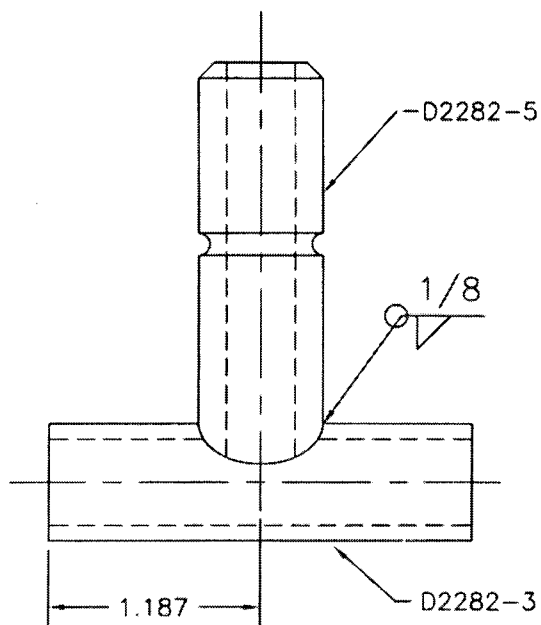
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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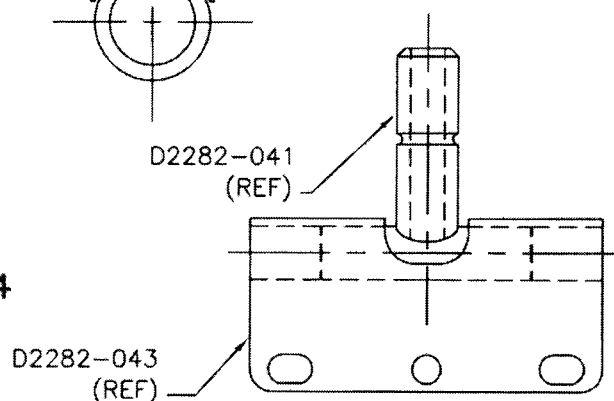


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CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

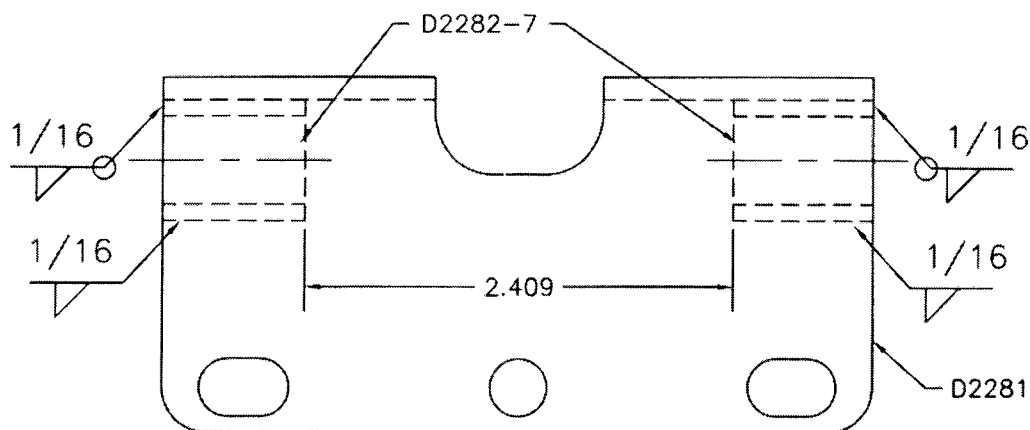


RELEASED
[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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